

ASAP

Date: Thursday, 3/27/2008 7:41:53 AM
User: *Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 38224	
Estimate Number : 13168	
P.O. Number :	Part Number : D37411
This Issue : 3/27/2008 S.O. No. :	Drawing Number : D3741 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37762	Material :
Written By :	Due Date : 4/2/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est Rev:A 08-01-30 new issue DD verified by:	
Est Rev:B 08-03-19 chg to revB DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6207	Angle Extrusion 1x1x.125
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Comment: Qty.: 0.0656 f(s)/Unit Total : 0.5250 f(s)

D6207 angle extrusion

Batch: M18147

JA

080328

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: 1-drill holes as per dwg D3741

2-Deburr

JA

080328

8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA

080328

8

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/07/08

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3741

2- Deburr if necessary

JA

080328

8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 38224

Part Number: D37411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Good on 2/28/08

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-31

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FR 08/03/31 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57118*

FR 08/03/31 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



mf 08-03-31

h

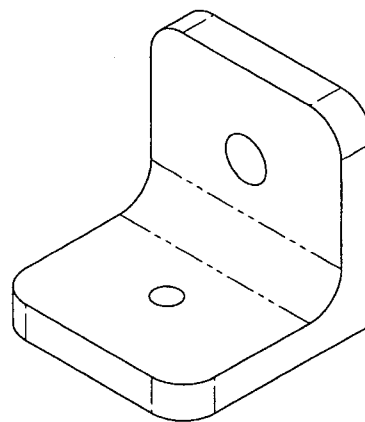
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



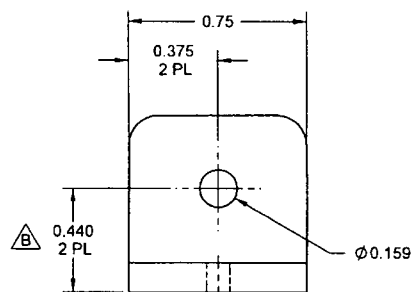
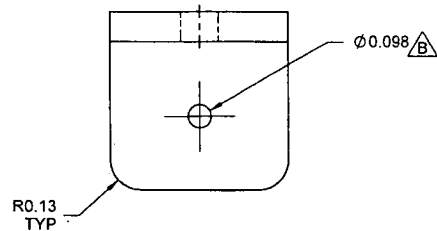
D3741-1 ANGLE $\triangle B$

NOTES:

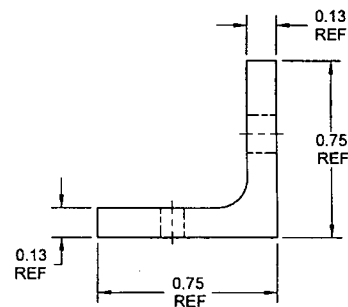
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125) $\triangle B$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

NO. 38224
 WORK ORDER
 WITHOUT NOTICE
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B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED. ISO VIEW UPDATED. SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159, ZONE 6B 0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	CE	DRAWING NO.	REV. B	
MFG. APPR.	DS	D3741	SHEET 1 OF 2	
APPROVED	JP	TITLE	SCALE	
DE APPR.	JP	ANGLE	NTS	
DATE	08.03.06			
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D3741-1 ANGLE




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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO. D3741	REV. B
MFG. APPR.	IS		SHEET 2 OF 2
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DE APPR.	SH	ANGLE	NTS
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FIRST ARTICLE INSPECTION CHECKLIST

☐ **First Article** ☐ **Prototype**

[illegible]

Measured by:	
Date:	080328

Audited by:	J.L.
Date:	08/02/28

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

